

Work Order ID 72329

Friday, July 22, 2011 12:30:22 PM



Page 1

Item ID: D135-751-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube Installation

Start Date: 7/22/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/3/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3492

C

D3507

Rev C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D135-751-011

CHG001

Silver 1/5

10 for CL 11-8-23

B72329

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut Aft end as per dwg D3507

2-Deburr ends

3-Drill Aft & Fwd Cap holes using DT8678 & DT8901

4-Locate DT8870 & Drill Ground wire hole on top of Tube.

6-Locate DT8870 with #30 cleco in Ground wire hole then Pilot Drill all X-Bolt holes using #30" drill. ****DO NOT OPEN AFT CAP HOLES****

7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868, Use DT8892 FOR REAR WEARPLATE HOLES.

8-Open six rear wearplate holes using DT8892. Open holes to 0.297"

9-Open Aft & Fwd Cap holes using .208" drill.

10-Bore out aft end of tube as per Dwg D3507 & Detail "B".

11-Open ground wire hole .297" section E-E

12- Section G-G holes must be laid out manually, open to #30.

13-Deburr holes.

1 0 BE 107/29

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Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8 u08/02					
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		11/08/02		xl			
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				1		861/08/02	

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Cust Item ID:

Required Date: 8/3/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Skidtubes	0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
	1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507 and Detail "F"								
	2-Counter Sink X-BOLT holes as per Dwg D3507								
	3-Deburr and blow out chips from inside of tube.								
	4-Bond web as per Dwg D3507 & QS1015								
	A/R 241 Sike Flex Batch: 1125/6								
	Exp Date: 12/6/15								
	start time: 11/08/02								
	end time: _____								
	5-Weld x-bolt (D3504-1/-3)spacers as per Dwg D3507 and Detail C-C & D-D.								
	A/R AL ROD Batch: m112860								
	6-Grind welds flush								
	7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B								
	8-Deburr Rivet holes.								

BE 11/08/02

BE 11/08/04

3DR 11/08/05

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

*Silvestros**(A)*

190

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Rivet D3506-1/-3 as per Dwg D3507.

*(X1)**B 11/08/08*

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*Silvestros**(A)*

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

IX ~~Ø~~ M-11/08/09

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 8:15AM
OVEN TEMPERATURE: 320F
FINISH TIME: 8:45AM1 ~~Ø~~ M-11/08/10

230

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

IX ~~Ø~~ M-11/08/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

260

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1- Install Wearplate & Ground Wire inserts as per Dwg D3507.

1-Inspect for Foreign objects

2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B"

A/R 241 Sika Flex Batch: _____

Exp Date: _____

3-Install Wearplates as per Dwg D3507,

Note: Install (1) Bolt and (1) washer on Ground Wire insert on top of tube

Do not Install Scews where indicated on Dwg (Note #6)

A/R 241 Sika Flex Batch: _____

Exp Date: _____

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: _____

5- Wing Walk as per Dwg D3507 and QSI 005 4.4

Batch: _____

M 118313

M 117516

01115

M 117516

01115

M 114189

M-1/BL 11-8-23.

W/O:		WORK ORDER CHANGES					
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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270

QC5- Inspect part completeness to step on W/O

0.00



0.00 8 u/c 7/23

QC

Memo

Quality Control

280

Pick Kit

0.00



0.00

Packaging

Memo

Packaging

J 8/11-08-25

290

QC4- 100% Inspect kits for completeness

0.00



0.00 8 u/c 8/15

QC

Memo

Quality Control

ⓧ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D135-751-011 Location: <u>B</u> PPP Rev: _____								
310 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/9/10
ME
11-09-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Friday, July 22, 2011 12:30:30 PM

Page 1

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Parent Item: D135-751-011

Parent Item Name: Skidtube Installation


Start Date: 7/22/2011

Required Date: 8/3/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 06-06-21 New Issue JLM
 IPP Rev:B 06-12-18 As per Rev B JLM
 IPP Rev:C 07-12-11 ECN 1036 as per revB DD
 IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC verified DD
 IPP Rev E 10.02.22 per pAR 09-043 EC verified by: DD IPP Rev:F
 10.06.09 remove seq110 DD verf:EC IPP Rev G 10.09.17
 added D3507-1-bent EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-130  Insert		Purchased	No				Each	1,899.000		38			
<div><div><div><div><div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><di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m-k 11/08/10

38X

BE 11/07/29
371201
BE 11/08/04

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 72329

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 7/22/2011

Required Date: 8/3/2011

Start Qty: 1.00

Required Qty: 1.00

D3504-3 Manufactured No

170 Each

20.0000 1 1



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG001

20

53743

20

D3504-5 Manufactured No

170 Each

17.0000 2 2



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

17

71226

17

D3505-1 Manufactured No

170 Each

0.0000 1 1



Web

D3506-1 Manufactured No

190 Each

23.0000 4 4



Doubler

Location

Loc Qty

Loc Code

ST063

23

51789

23

D3506-3 Manufactured No

190 Each

75.0000 2 2



Doubler

Location

Loc Qty

Loc Code

ST063

75

51790

75

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, July 22, 2011 12:30:31 PM

Work Order ID: 72329

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 7/22/2011

Required Date: 8/3/2011

Start Qty: 1.00

Required Qty: 1.00

MS20601-AD4W3 Purchased

No

190

Each

2,714.000

12

12



Rivet



12

11/08/08 ~~11~~

Location

Loc Qty

Loc Code

ST321

2714

114538

2714

ALS4-1032-225 Purchased

No

260

Each

973.0000

1

1



Insert



m-p 11/08/10

Location

Loc Qty

Loc Code

ST282

973

110768

104

117717

9

118386

860

AN3C4A Purchased

No

260

Each

1,396.000

31

31



BOLT



m-p 11/08/10

Location

Loc Qty

Loc Code

ST350

1396

117313

2

117688 ✓

332

117795

500

117872

22

118012

500

118112

40

312

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, July 22, 2011 12:30:31 PM

Work Order ID: 72329

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 7/22/2011

Required Date: 8/3/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C5A Purchased No 260 Each 1,039.000 2 2
Bolt

Location	Loc Qty	Loc Code
FP-A	7	
115835	7	
ST350	1032	
116419	28	
116549	42	
117343	500	
117764	300	
117872	162	



mt 11/08/10

AN526C1032R10 Purchased No 260 Each 229.0000 2 2
Screw

Location	Loc Qty	Loc Code
FP-B	105	
108062	105	
ST327	100	
114494	100	
ST328	24	
110049	24	



mt 11/08/10

AN960C10L NAS1149C0332 Purchased No 260 Each 0.0000 33 33
R



washer D2965 Manufactured No 260 Each 6.0000 1 1
Cap, 105 Skidtube

Location	Loc Qty	Loc Code
FP006	6	
52057	6	



M118306

33x mt 11/08/10



xl 11/08/10

B71371

xl

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, July 22, 2011 12:30:31 PM

Work Order ID: 72329

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 7/22/2011

Required Date: 8/3/2011

Start Qty: 1.00

Required Qty: 1.00

D2965-3
Cap

Manufactured No

260 Each

11.0000

1

1

m-l 11/08/10

Location

Loc Qty

Loc Code

FP005

11

50560 ✓

1

71300 ✓

10

1X

D3492-1
Plug

Manufactured No

260 Each

52.0000

4

m-l 11/08/10

Location

Loc Qty

Loc Code

FP

52

69531 ✓

8

69819 ✓

44

4X

D3492-3
Plug

Manufactured No

260 Each

60.0000

4

m-l 11/08/10

Location

Loc Qty

Loc Code

FP

60

69822 ✓

12

70692 ✓

48

4X

D3492-7
Plug

Manufactured No

260 Each

0.0000

2

B 71851

2X m-l 11/08/10

D3508-1
Wearplate

Manufactured No

260 Each

10.0000

1

m-l 11/08/10

Location

Loc Qty

Loc Code

FP016

10

61020 ✓

10

1X

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, July 22, 2011 12:30:32 PM

Work Order ID: 72329

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 7/22/2011

Required Date: 8/3/2011

Start Qty: 1.00

Required Qty: 1.00

D3558-5
Gasket
Manufactured No 260 Each 12.0000



1 1
m-p 11/08/10

Location

Loc Qty

Loc Code

FP014

12

67485 ✓

12

D3558-7
Gasket
Manufactured No 260 Each 14.0000



1 1
m-p 11/08/10

Location

Loc Qty

Loc Code

FP014

14

67162 ✓

14

NAS1611-007
O-RING
Purchased No 260 Each 290.0000



2 2
m-p 11/08/10

Location

Loc Qty

Loc Code

FP-A

290

103697 ✓

290

NAS1611-010
O-RING
Purchased No 260 Each 118.0000



4 4
m-p 11/08/10

Location

Loc Qty

Loc Code

FP

40

117460 ✓

8

118077 ✓

32

FP-A

78

110915

75

115589

3

4x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 8

Friday, July 22, 2011 12:30:32 PM

Work Order ID: 72329

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 7/22/2011

Required Date: 8/3/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased

No

260

Each

296.0000

4

4



O-RING

Location

Loc Qty

Loc Code

FP

91

117291

2

117887

89

FP-A

205

116582

5

118384

200

AN3C4A

Purchased

No

280

Each

1,396.000

8

8



BOLT

Location

Loc Qty

Loc Code

ST350

1396

117313

2

117688

332

117795

500

117872

22

118012

500

118112

40

AN960C10L

NAS1149C0332
R

Purchased

No

280

Each

0.0000

8

8



washer

D3512-1

Manufactured

No

280

Each

9.0000

2

2



Wearplate

Location

Loc Qty

Loc Code

ST500

9

71592

9

71795

Friday, July 22, 2011 12:30:32 PM

Shop Packet Print

Page 8

m-1 11/08/10

4X

sp 11-08-25

m1186288x

m118354 8

sp 11-08-25

sp 11-08-25

1x B 73038 sp 11-09-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

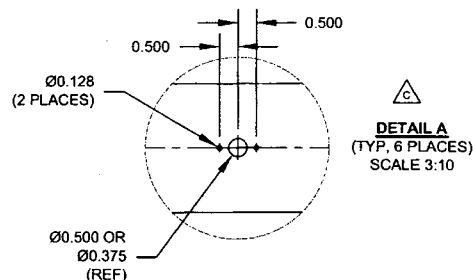
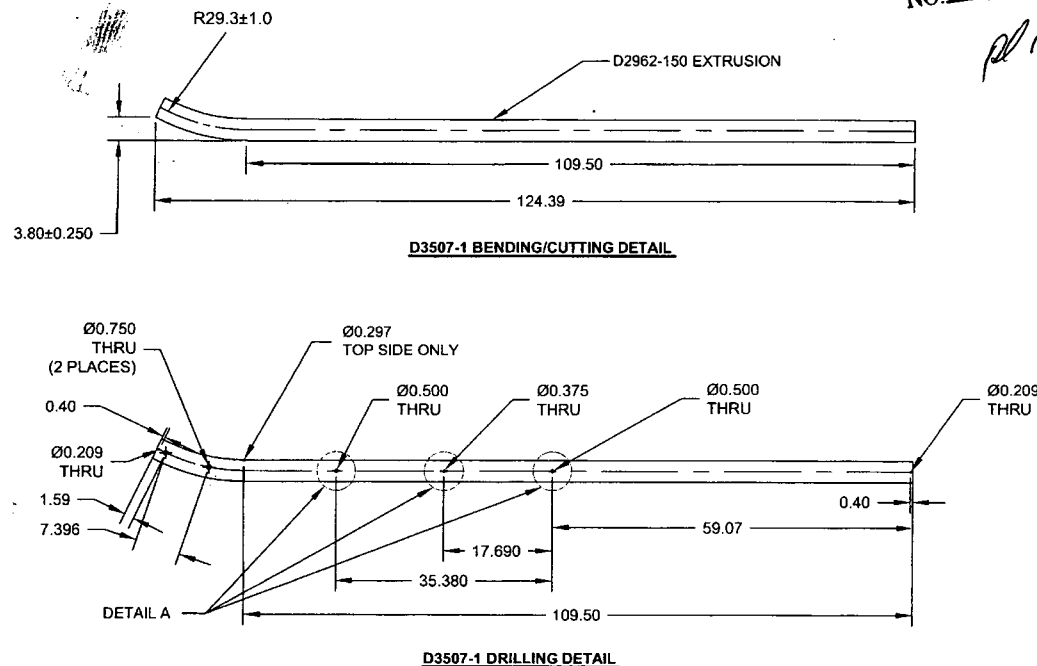
SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72329
P/1107-22

Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

GENERAL NOTES:

- 1) FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING
D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART
QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER
DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND
WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER
DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38
PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38
PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED
LOCATIONS

C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	JTC		
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3507	SHEET 1 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	EC 135 SKIDTUBE	NTS
DATE	07.09.19	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



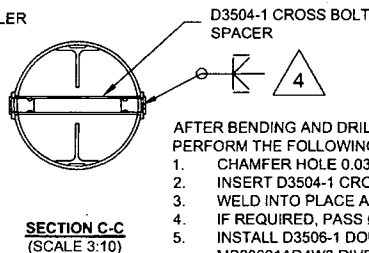
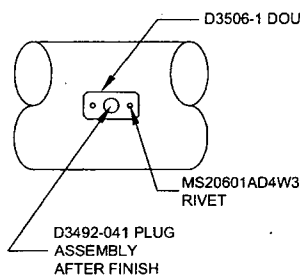
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

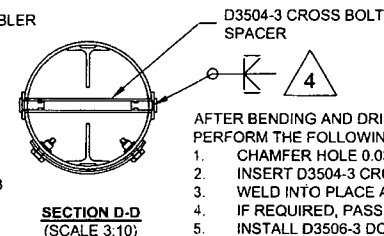
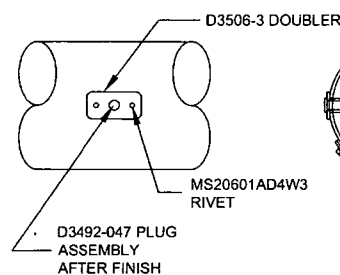
NOTE: Date & initial all entries



AFTER BENDING AND DRILLING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.500 HOLES ONLY:

1. CHAMFER HOLE 0.030 x 45°
2. INSERT D3504-1 CROSS BOLT SPACER (2 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. IF REQUIRED, PASS Ø0.404 (Y) DRILL THRU HOLE
5. INSTALL D3506-1 DOUBLER (4 PLACES) USING MS20601AD4W3 RIVET (8 PLACES)
6. AFTER FINISH, INSTALL D3492-041 PLUG ASSEMBLY (4 PLACES)

SECTION C-C
(SCALE 3:10)

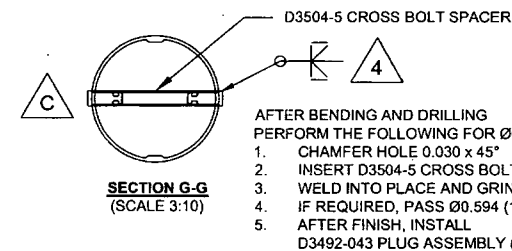
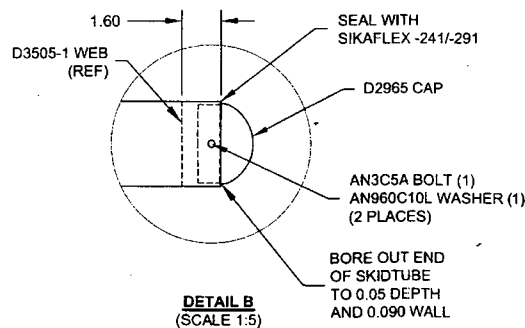
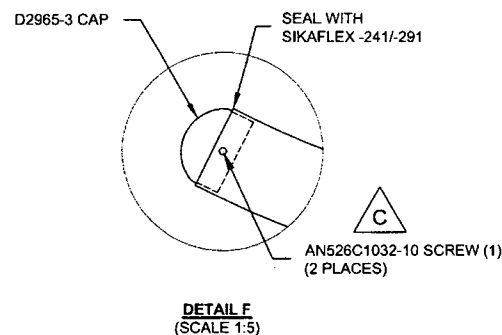
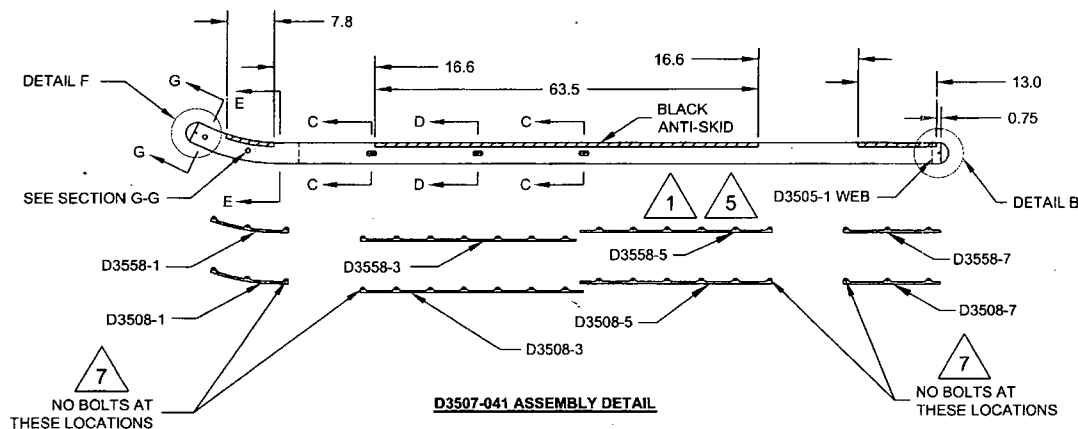


AFTER BENDING AND DRILLING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:

1. CHAMFER HOLE 0.030 x 45°
2. INSERT D3504-3 CROSS BOLT SPACER (1 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. IF REQUIRED, PASS Ø0.277 (J) DRILL THRU HOLE
5. INSTALL D3506-3 DOUBLER (2 PLACES) USING MS20601AD4W3 RIVET (4 PLACES)
6. AFTER FINISH, INSTALL D3492-047 PLUG ASSEMBLY (2 PLACES)

SECTION D-D
(SCALE 3:10)

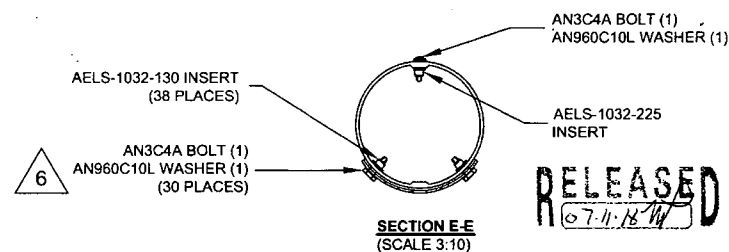
w/o 92329



AFTER BENDING AND DRILLING PERFORM THE FOLLOWING FOR Ø0.750 HOLES ONLY:

1. CHAMFER HOLE 0.030 x 45°
2. INSERT D3504-5 CROSS BOLT SPACER (2 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. IF REQUIRED, PASS Ø0.594 (19/32 DRILL) THRU HOLE
5. AFTER FINISH, INSTALL D3492-043 PLUG ASSEMBLY (4 PLACES)

SECTION G-G
(SCALE 3:10)



DESIGN	PH	DART AEROSPACE USA, INC
DRAWN	SC	PORT HADLOCK, WA
CHECKED	SC	DRAWING NO. D3507
MFG. APPR.	SC	REV. C SHEET 2 OF 2
APPROVED	PH	TITLE EC 135 SKIDTUBE SCALE 1:20
DE APPR.	PH	
DATE	07.09.19	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

RELEASED
07-11-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 257

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: B666P
Part number: D135-751-011
Description: 135
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat. Lewis Date of Test Coupon 11-06-22
Welder Barclay Elliot Date of Test Coupon 11-06-22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld